

Date: Friday, 5/25/2007 8:16:47 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FORWARD CAP - UNDER REVIEW
Job Number	: 32584		
Estimate Number	: 10501		
P.O. Number	: N/A	Part Number	: D2744
This Issue	: 5/25/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2744 UNDER REVIEW
First Issue	: N/A	Project Number	: N/A
Previous Run	: 29784	Drawing Revision	: B1
		Material	: N/A
		Due Date	: 6/30/2007
Written By	: <u>07.05.28</u>	Qty:	30 Um: Each
Checked & Approved By	: <u>07.05.28</u>		
Comment	: Est C 03.01.17 Reformat; Dwg revised KJ/RF Est Rev:D Now on Waterjet 06-06-16 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M5052H32S080	5052-H32 .080 Sheet
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Comment: Qty.: 0.1914 sf(s)/Unit Total: 5.7425 sf(s)
 Material: 5052-H32 (QQ-A-250/8) or 6061-T6 (QQ-A-250/11) 0.080 thick.
 Use off-cuts
 M5052H32S.080) Batch m104392X⁴⁻⁶⁰⁶¹ ml 07 06 10 (30)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2744
 Dwg Rev: B1 ml 07 06 10 (30)
 Prog Rev: B1

2-Deburr if necessary mf 07-06-25 (30)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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ml 07 06 10 (30)



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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07.06.11 (30)



Comment: SECOND CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: BARCLAY

07/06/26 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

2010/06/26

Job Completion



U 87-0626






W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN 	DRAWN BY 	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D2744	REV. B SHEET 1 OF 1
DATE 02.12.18		TITLE CAP	SCALE 1:1
A	98.04.16	NEW ISSUE	
B	02.12.18	REDESIGN	
Bi	 04.03.10	6.52 WAS 6.27 ; 3.26 WAS 3.13	

RELEASED
02.12.18

~~UNDER REVIEW~~

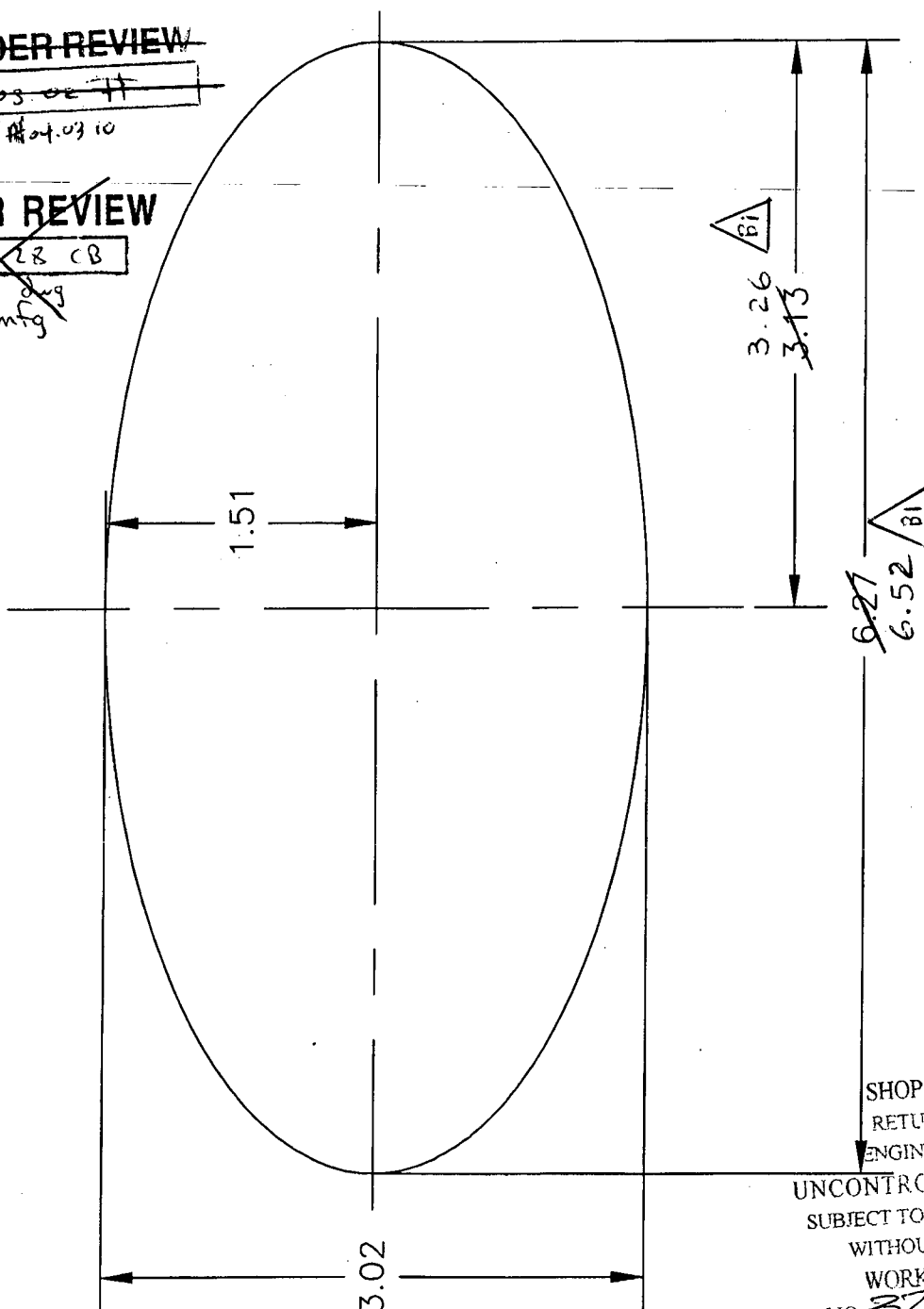
04.03.02 TT

OK 04.03.10

~~UNDER REVIEW~~

~~06.06.28 CB~~

~~update drug
OK to mfg~~



SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32584

NOTES

- NOTES:
- 1) MATERIAL: 6061-T6 (QQ-A-250/11) OR 5052-H32 (QQ-A-250/8), 0.080 THICK (REF. DART SPEC M6061T6S.080 OR M5052H32S.080)
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES

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